Work Order ID 57761

April 14, 2010 11:42:12 AM

Item ID: D3135-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Handle Weldment

Start Date: 4/14/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 4/20/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D3135 / Rev D									
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				HB 10-4-27			
FLOW CNC Waterjet	1-Cut as per Dwg D3135 ☐Dwg Rev: D ☐Prog Rev: D ☐2-Deburr if necessary								
304 .063						(2)			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				HB 10-4-27			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00				(2)			
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 57761

April 14, 2010 11:42:13 AM

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Start Date: 4/14/10 **Start Qty:** 2.00 **Cust Item ID:**

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Run Start **Stop**

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Small Fab	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	1-Bend D3135-1 as per template D3135-1T2 and Dwg D3135□2-Deburr ends								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
150		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
Large Fab	1-Weld handle onto plate as per Dwg D3135 and QSI 004□ 304 S.S. welding rod Batch: M108160								

2X 7 M.L 10/05/12

8 10/05/12 (x2)

EL 10-5-13 (x2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 1:00pm OVEN TEMPERATURE: 1:30pm FINISH TIME: 320°F								

10/05/14

10/05/17

1411258B

10/05/18 X2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 57761

April 14, 2010 11:42:14 AM

Item ID: D3135-041 **Accept** **Setup Start** **Stop**

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00				2	BR 10-5-18.		
QC	**Memo**	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: 236B	0.00				10-5-10			
Packaging	**Memo**	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00				10/05/19			
QC	**Memo**	0.00							
Quality Control						MF 10-5-18			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:42:12 AM

Work Order ID: 57761

Parent Item: D3135-041

Parent Item Name: Handle Weldment

Start Date: 4/14/10 **Required Date:** 4/20/10

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP: A□03.03.06□New Issue□KJ/RF□□
IPP Rev:B 08-01-15 now on water jet DD
IPP Rev:C 08-05-22 revD as per dwg ECN1192 DD verified by:EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S16GA		Purchased	No			130	sf	16.5700	0.6316		4-27-10	
304/316 Sheet .063												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT20	16.57	
113295	16.57	

114467

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304TR0.375W.065		Purchased	No		114467	100	f	38.4160	0.8773			
304 RD Tube .375 x .065W												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT016	38.416	
111097	38.416	

0.8773 10/05/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	5771
Description: Plate	Part Number:	D3135-3
Inspection Dwg: D3135 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

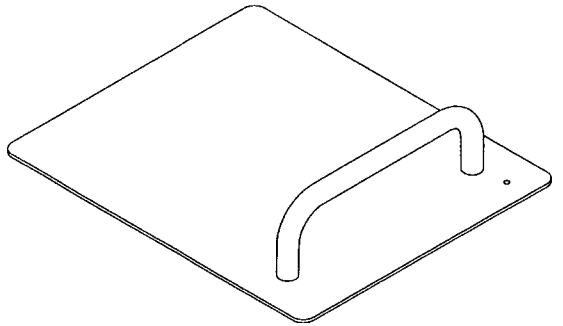
[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.10	+0.004/-0.001	.104	✓			
0.50	+/-0.030	.500	✓			
0.68	+/-0.030	.681	✓			
7.20	+/-0.030	7.201	✓			
6.00	+/-0.030	6.012	✓			
0.063	+/-0.010	.061	✓			

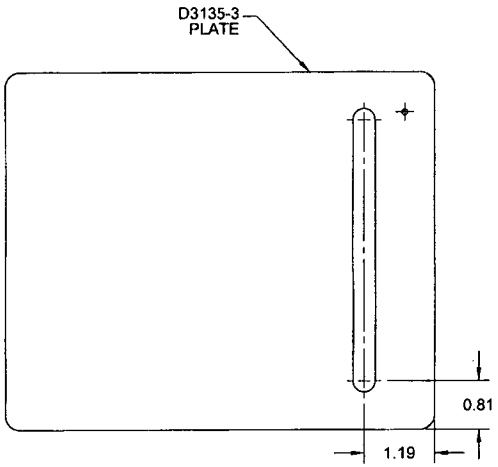
Measured by:	AB	Audited by:	S	Prototype Approval:	N/A
Date:	10-4-07	Date:	10/04/07	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	09.10.01	New Issue	P/O D3135-041	KJ	

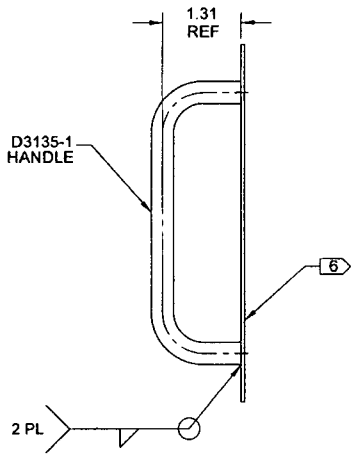
QTY. -041	PART NUMBER	DESCRIPTION
X	D3135-041	HANDLE WELDMENT
1	D3135-1	HANDLE
1	D3135-3	PLATE



D3135-041 HANDLE WELDMENT



D3135-041 HANDLE WELDMENT



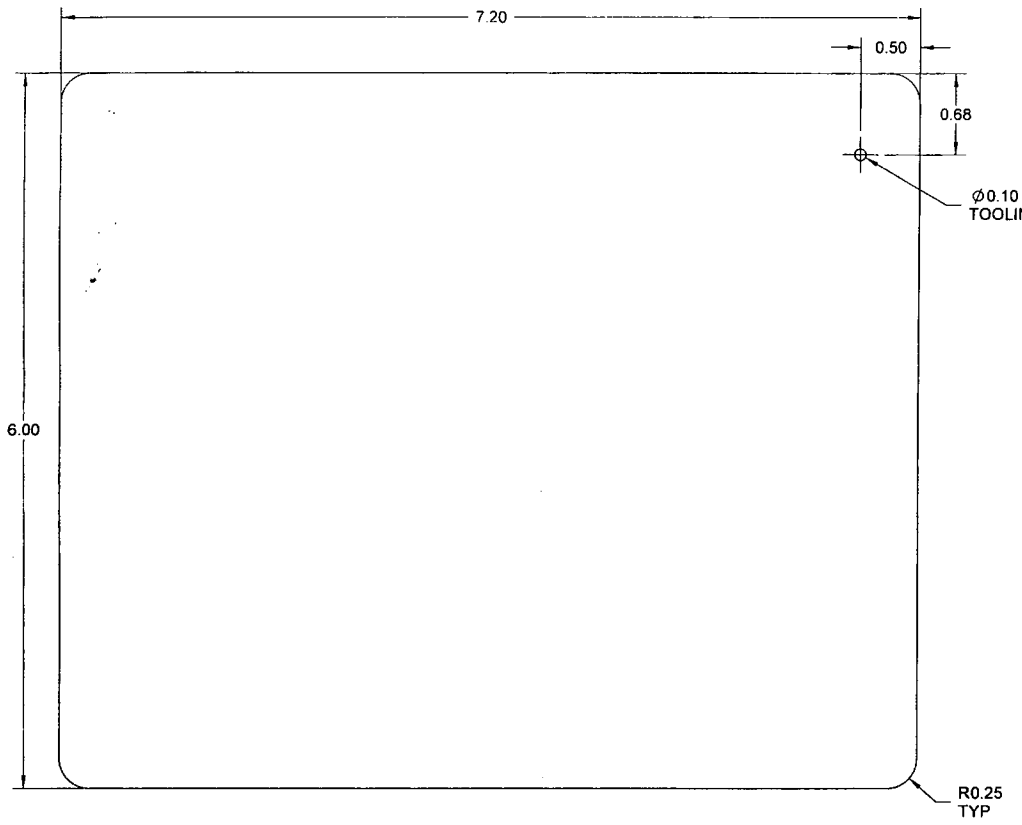
RELEASED
06-05-22

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT COLOUR GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3135-041" AND BATCH "BXXXXX" USING FINE POINT PERMANENT INK MARKER OR FIX LABEL AFTER FINISHING
7) WEIGHT: 0.90 lbs
8) WELD PER DART QSI 004

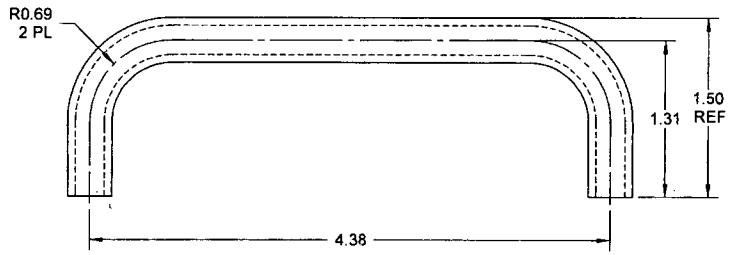
REV.	DESCRIPTION	BY	DATE
D	REDRAWN TO SOLIDWORKS FORMAT. ZN D4-2 TOOLING HOLE ADDED. REASON: PRODUCTION REQUEST FOR TOOLING HOLE.	AJS	08.05.07
C	REMOVED Ø0.221 HOLES	DS	04.10.06
B	6.400 WAS 6.330; ADD "ANNEALED"	DS	03.03.04
A	NEW ISSUE	DS	02.04.17

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3135 REV. D SHEET 1 OF 2
MFG. APPR.		
APPROVED		TITLE HANDLE WELDMENT SCALE NTS
DE APPR.		
DATE	08.05.07	

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D3135-3 PLATE



D3135-1 HANDLE

NOTES:
1) MATERIAL: -1 HANDLE
AISI 304/316, STAINLESS STEEL ROUND TUBE, Ø0.375 x 0.065 WALL
(ANNEALED)
(REF. DART SPEC M304TR0.375W.065)
-3 PLATE
AISI 304/316 STAINLESS STEEL SHEET, 0.063 THICK
PER AMS 5513 OR AMS 5524 (ANNEALED)
(REF. DART SPEC M304S16GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.12 lbs -1 HANDLE
: 0.78 lbs -3 PLATE

WO 37261

RELEASED 08.05.22

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3135 REV. D SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE HANDLE WELDMENT SCALE NTS
DE APPR.		
DATE	08.05.07	

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